

duplicate

Date: Monday, 14/04/2008 9:06:22 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: R/H LOW PROFILE BASKET BASE ASS'Y		
Job Number	: 38460			Part Number	: D3712042		
Estimate Number	: 13171			Drawing Number	: D3712 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 14/04/2008	S.O. No.	:	Drawing Revision	: B		
Prsh't Rev.	: NC			Material	:		
First Issue	: 08/04/2008	Type	: LARGE FAB ASSY	Due Date	: 25/04/2008	Qty:	1
Previous Run	: 38217			Um:	Each		
Written By	:						
Checked & Approved By	: JLD 08.4.14						
Comment	: Est Rev:A new issue 08-01-30 DD verified by:EC Est Rev:B chg to revB ecn 1145 08-03-19 DD verified by:						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
 		
Comment: Qty.: 44.7920 f(s)/Unit Total : 44.7920 f(s) 304 SQ Tube.75x.75x.065W		
1- Cut Ribs as per dwg from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing. QTY PART NUMBER BATCH 2 D3726-1 <u>M107514</u> 2 D3727-1 <u>M107514</u> 2 D3734-1 <u>M107514</u> 6 D3735-1 <u>M107514</u> 3 D3739-1 <u>M107514</u> 3 D3740-1 <u>M107514</u>		
2- deburr		
2.0	D23273	Spacer Bushing
 		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Spacer Bushing batch <u>336479</u> ✓		
3.0	D2581	Mounting Bracket
 		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Mounting Bracket batch <u>D37248</u> ✓		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
4.0	D37251	HOOP
		Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s), HOOP batch: 337127 → 1 B38169 → 1 ✓ <i>P108-04-22</i>
5.0	D37481	HINGE HALF
		Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s) HINGE HALF batch: 337305 → 1 B38225 → 2 ✓ <i>P108-04-22</i>
6.0	D31661	Basket Hoop
		Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s) Basket Hoop Batch: 337572 ✓ <i>P108-04-14</i> <i>APR</i>
7.0	D37591	BUSHING
		Comment: Qty.: 21.0000 Each(s)/Unit Total: 21.0000 Each(s) BUSHING batch: 338236 → 7 B38416 → 14 ✓ <i>P108-04-22</i>
8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1- take D3166-1 and trim as per dwg D3746 to make D3746-1, D3746-3, D3746-5 and D3746-7

2- take D3746-3, D3746-5, D3746-7 and drill holes as per dwg D3746 using drill jig DT8995 and DT8996

3- drill holes in both D3727-1 as per dwg D3727

4- drill holes in D3735-3 as per dwg D3735

5- deburr

6- assemble as per dwg D3712 and weld as per QSI004

16 08-04-20 *P108-04-22*

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Part Number: D3712042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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9.0	M304EX07516F	Expanded Metal Flat Stai
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Comment: Qty.: 39.9000 sf(s)/Unit Total : 39.9000 sf(s)

Expanded Metal Flat Stainless Steel

Pick:

Qty	Part Number	Description	Batch
38sq.ft	M304EX0.75-16F	Expanded Metal	<i>m107511✓</i>

SA11 08/04/22

10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- cut mesh to fit inside basket base and sides as per dwg D3744 and D3745

SAY 08/04/22

2- weld mesh as per dwg D3712

PL 08-04-23

11.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5-08/04/24 QW

12.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

PL 08/04/24

13.0	POWDER COATING	POWDER COATING
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M 107500

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

PL 08-04-24

X

14.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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M- 08/04/24

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

*3384160
1237120012
24/04/2008*

S.115	15.20
#1	402.9 F
#2	----- F
#3	30mtr F
#4	----- F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Part Number: D3712042

Job Number:



Seq. #:	Machine Or Operation:	Description :	
16.0	D2931	Bumper	
			<i>AS 08/04/28 (xi)</i>
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Bumper	<i>21139</i>
17.0	AN311A	Bolt	
			<i>AS 08/04/28 (xi)</i>
		Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)	
		Bolt	<i>M14820</i>
18.0	AN960JD8	Washer	
			<i>AS 08/04/28 (xi)</i>
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Washer	<i>M107091</i>
19.0	AN960JD10	Washer	
			<i>AS 08/04/28 (xi)</i>
		Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)	
		Washer	<i>M107715</i>
20.0	MS20600AD4W3	Cherry Rivets	
			<i>AS 08/04/28 (xi)</i>
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Cherry Rivets	<i>M18071</i>
21.0	MS21042L3	Nut	
			<i>AS 08/04/28 (xi)</i>
		Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)	
		Nut	<i>M107644</i>
22.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			<i>AS 08/04/28 (xi)</i>
		Comment: Assemble as per dwg D3712	<i>M108/04/28</i>
23.0	QC5	INSPECT WORK TO CURRENT STEP	
			<i>AS 08/04/28 (xi)</i>
		Comment: INSPECT WORK TO CURRENT STEP	<i>M108/04/28</i>

~~21.B Still missing 2x Blanking plate~~

~~** B38068~~

~~4x B38775~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/04/28	22	Still Missing : 2x Blanking plate 1x <u>B38068</u> 1x <u>B38775</u>	ml 08/04/28	08/04/28	2	u	G 08/04/28

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number:



Seq. #:	Machine Or Operation:	Description :
24.0	PACKAGING 1	PACKAGING RESOURCE #1
		(2)
	Comment: PACKAGING RESOURCE #1 Identify and Stock / Location: 38443	8/4/28 SLP
25.0	QC21	FINAL INSPECTION/W/O RELEASE
		08/04/28 (2)
	Comment: FINAL INSPECTION/W/O RELEASE	

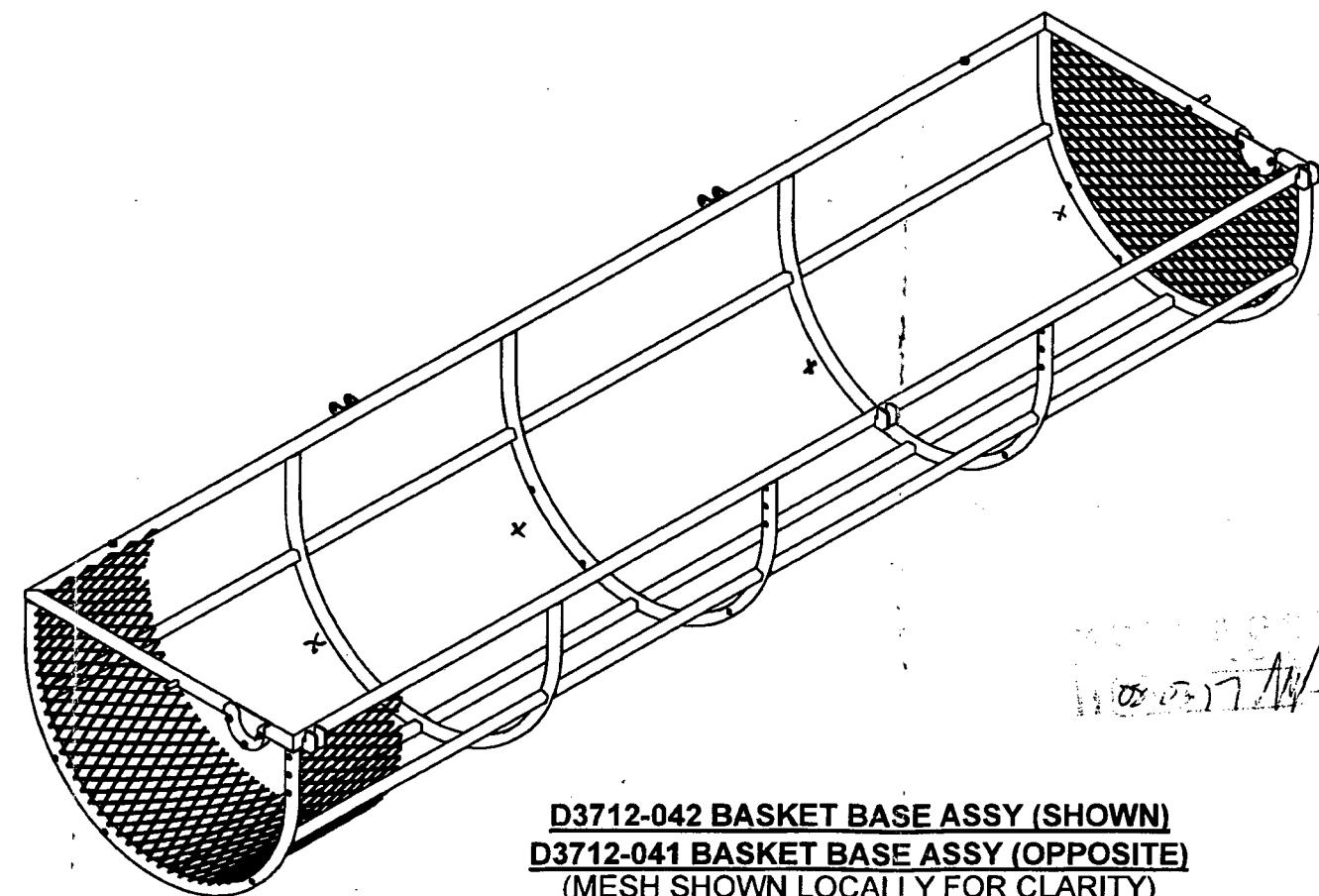
Job Completion



10/04/28

8 7 6 5 4 3 2 1

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3712-041	BASKET BASE ASSEMBLY
X		D3712-042	BASKET BASE ASSEMBLY
2	2	D2327-3	SPACER BUSHING
2	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
2	2	D3725-1	HOOP
2	2	D3726-1	RIB
2	2	D3727-1	RIB
2	2	D3734-1	RIB
5	5	D3735-1	RIB
1	1	D3735-3	RIB
3	3	D3739-1	RIB
3	3	D3740-1	RIB
1	1	D3744-1	MESH
1	1	D3746-1	RIB
1	1	D3746-3	RIB
2	2	D3746-5	RIB
1	1	D3746-7	RIB
3	3	D3748-1	HINGE HALF
2	2	D3757-1	BLANKING PLATE
21	21	D3759-1	BUSHING
6	6	AN3-11A	BOLT
2	2	AN960JD8	WASHER
12	12	AN960JD10	WASHER
2	2	MS20600AD4W3	RIVET
6	6	MS21042L3	NUT



D3712-042 BASKET BASE ASSY (SHOWN)

D3712-041 BASKET BASE ASSY (OPPOSITE)

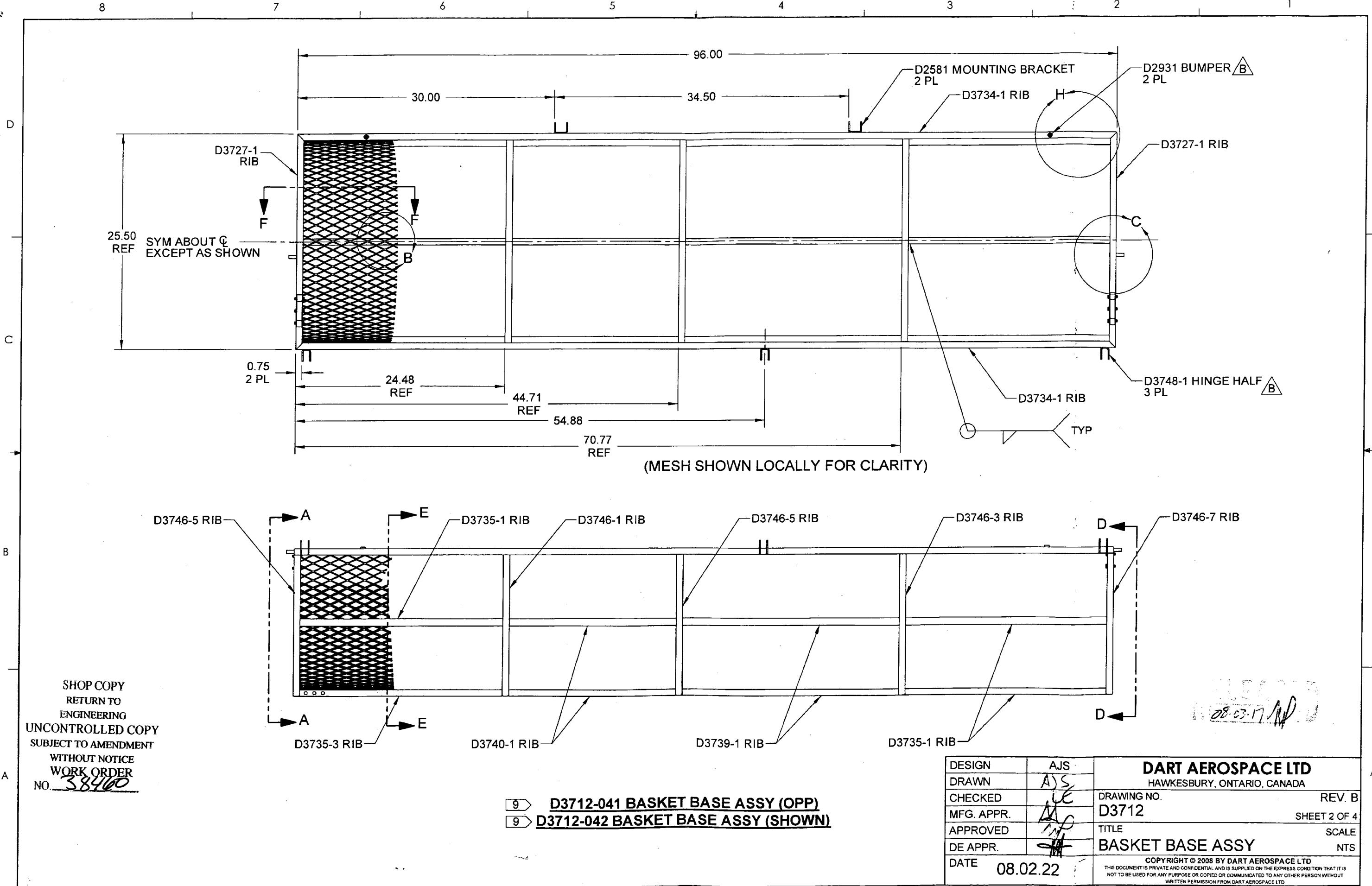
(MESH SHOWN LOCALLY FOR CLARITY)

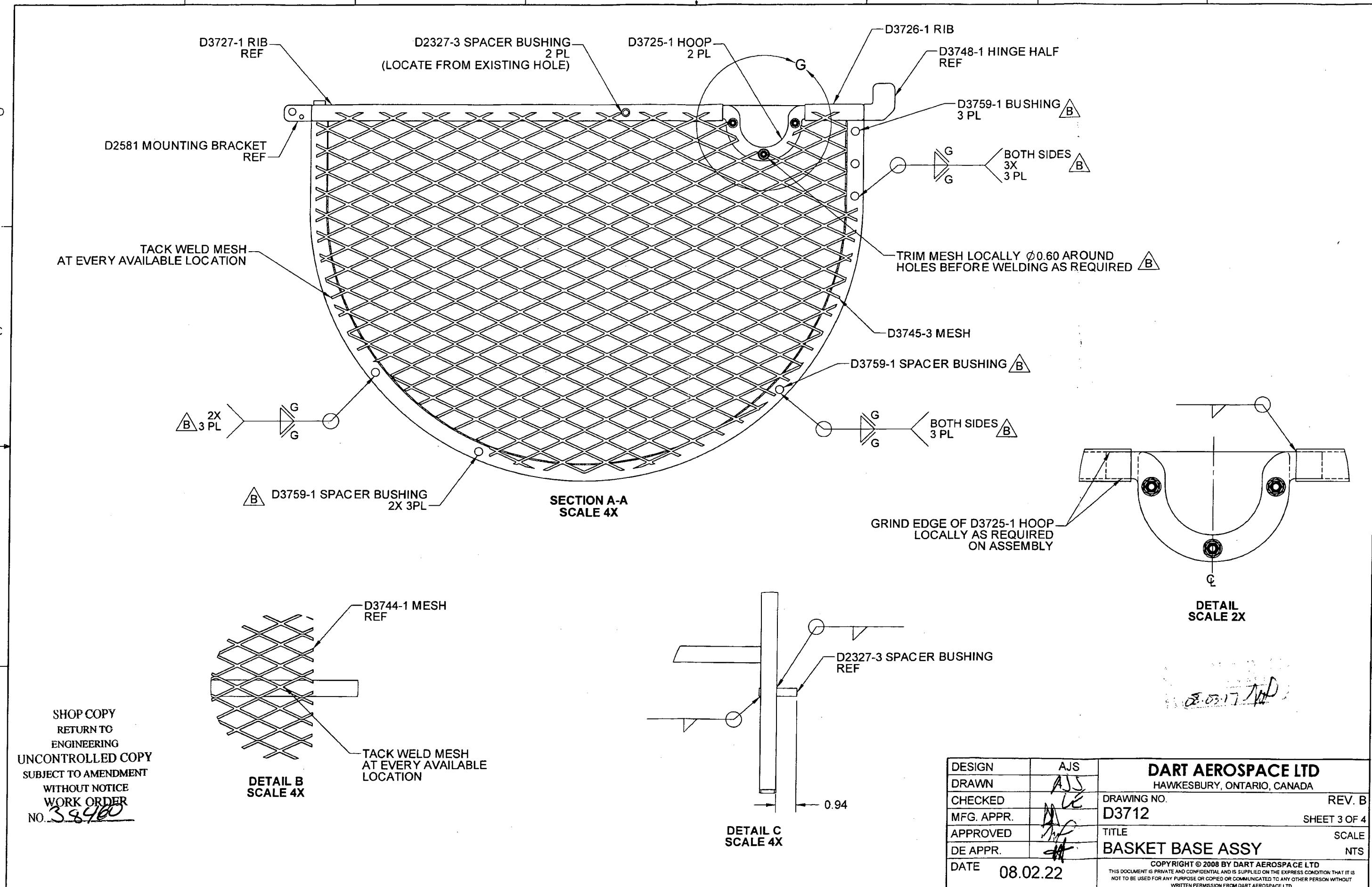
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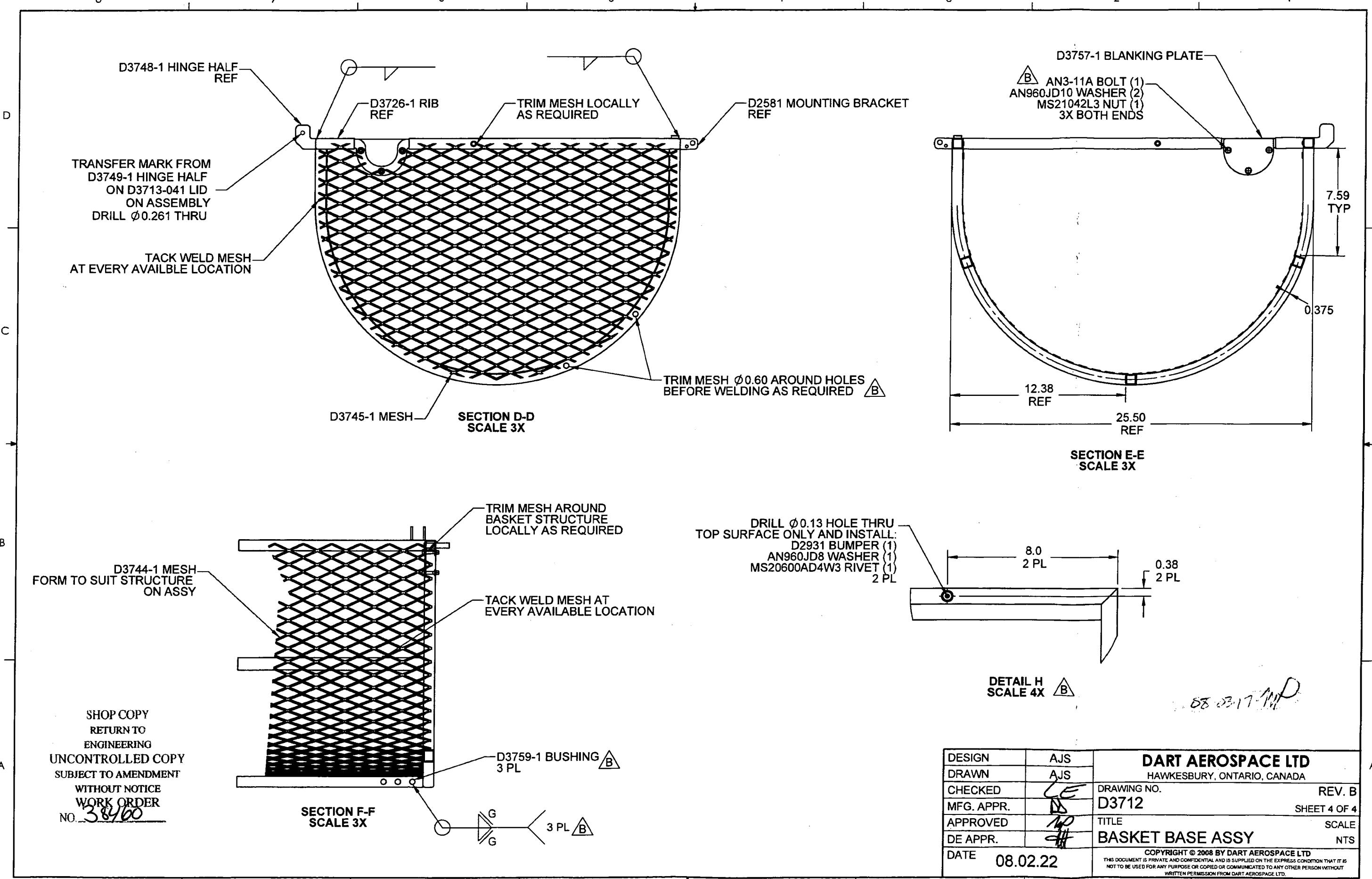
NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A B
- 8) WELDING: PER DART QSI 004
- 9) MASK ALL HOLES PRIOR TO POWDER COATING.

B	ADDED-041 ASSEMBLY. WEIGHT WAS 41.50 lbs. ADDED D2931 BUMPER & HARDWARE & D3759-1 BUSHINGS. SHEET 2 ZONE C2 QTY FOR D3748-1 WAS 2. SHEET 4 ADDED DETAIL H. SHEET 3 ZONE C3 & SHEET 4 ZONE C4, ADDED MESH TRIMMING INSTRUCTIONS. SHEET 4 ZONE D2 AN3-11A BOLT WAS AN3-10A P/L UPDATED ACCORDINGLY.	AJS	08.02.22
A	NEW ISSUE	AJS	08.01.29
REV.	DESCRIPTION		
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>CE</i>	DRAWING NO. D3712	
MFG. APPR.	<i>DS</i>	REV. B SHEET 1 OF 4	
APPROVED	<i>NO</i>	TITLE BASKET BASE ASSY	
DE APPR.	<i>#</i>	SCALE NTS	
DATE	08.02.22	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	







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D3746-1 RIB

D3746-3 RIB

D3746-5 RIB

D3746-7 RIB

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WORK ORDER

NO. 384160

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
(REF. DART SPEC. M304TS0.750W0.065)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.25 lbs
- 8) M/F D3166-1 BASKET HOOP

A

A

B	SHEET 2 ZONE C4, B4 & SHEET 3 ZONE C7, HOLES WERE Ø0.257. SHEET 3 ZONE B2 & B5 HOLES WERE Ø0.191. SHEET 3 ZONE 7B HOLE QTY WAS 4PL.		AJS	08.03.03			
A	INITIAL RELEASE		AJS	08.01.28			
REV.	DESCRIPTION			BY DATE			
DESIGN	AJS	DART AEROSPACE LTD					
DRAWN	<u>AJS</u>	HAWKESBURY, ONTARIO, CANADA					
CHECKED	<u>LE</u>	DRAWING NO.					
MFG. APPR.	<u>SL</u>	REV. B					
APPROVED	<u>W</u>	D3746					
DE APPR.	<u>W</u>	SHEET 1 OF 3					
DATE	TITLE						
	RIB						
	SCALE						
	NTS						
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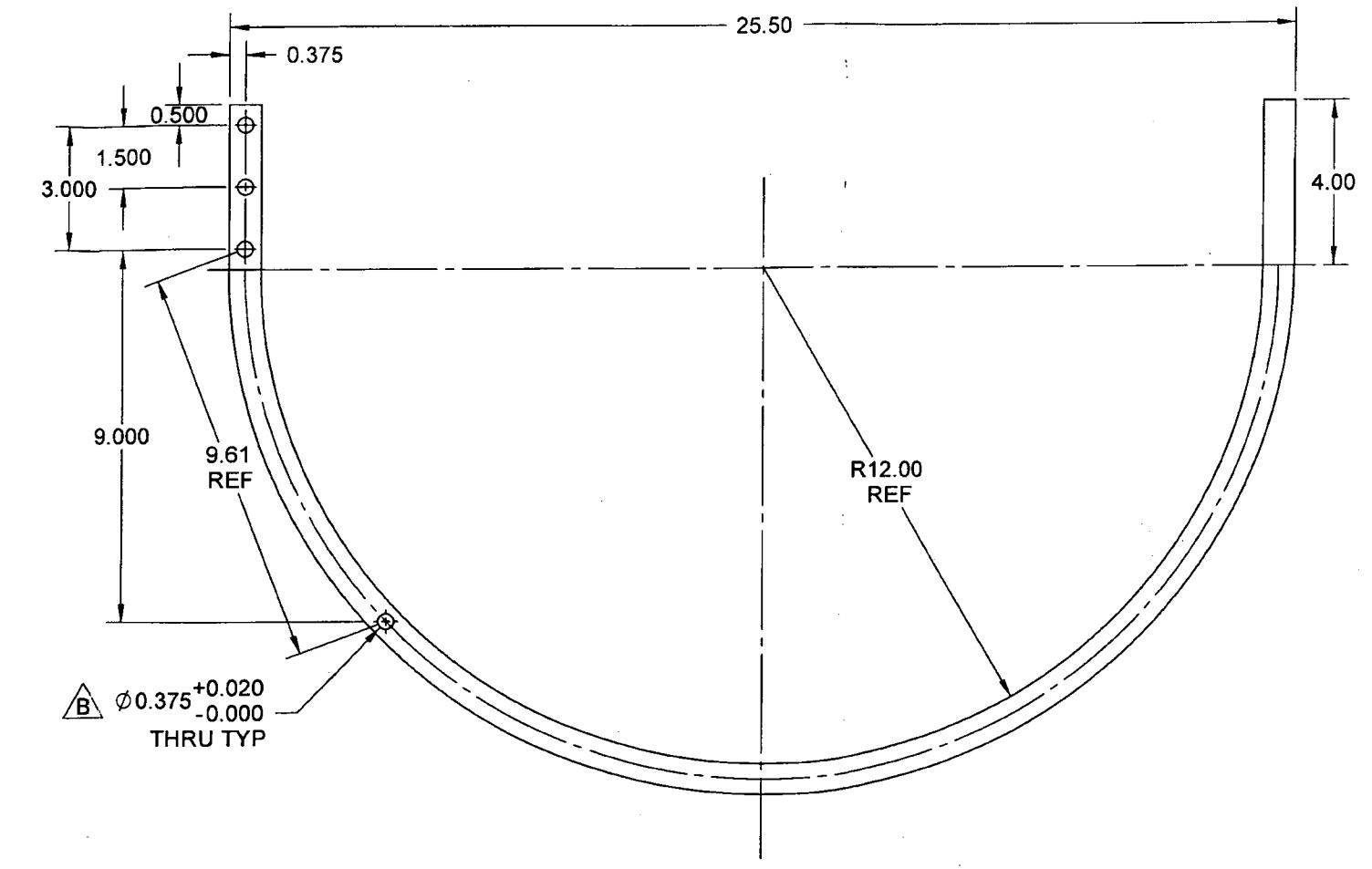
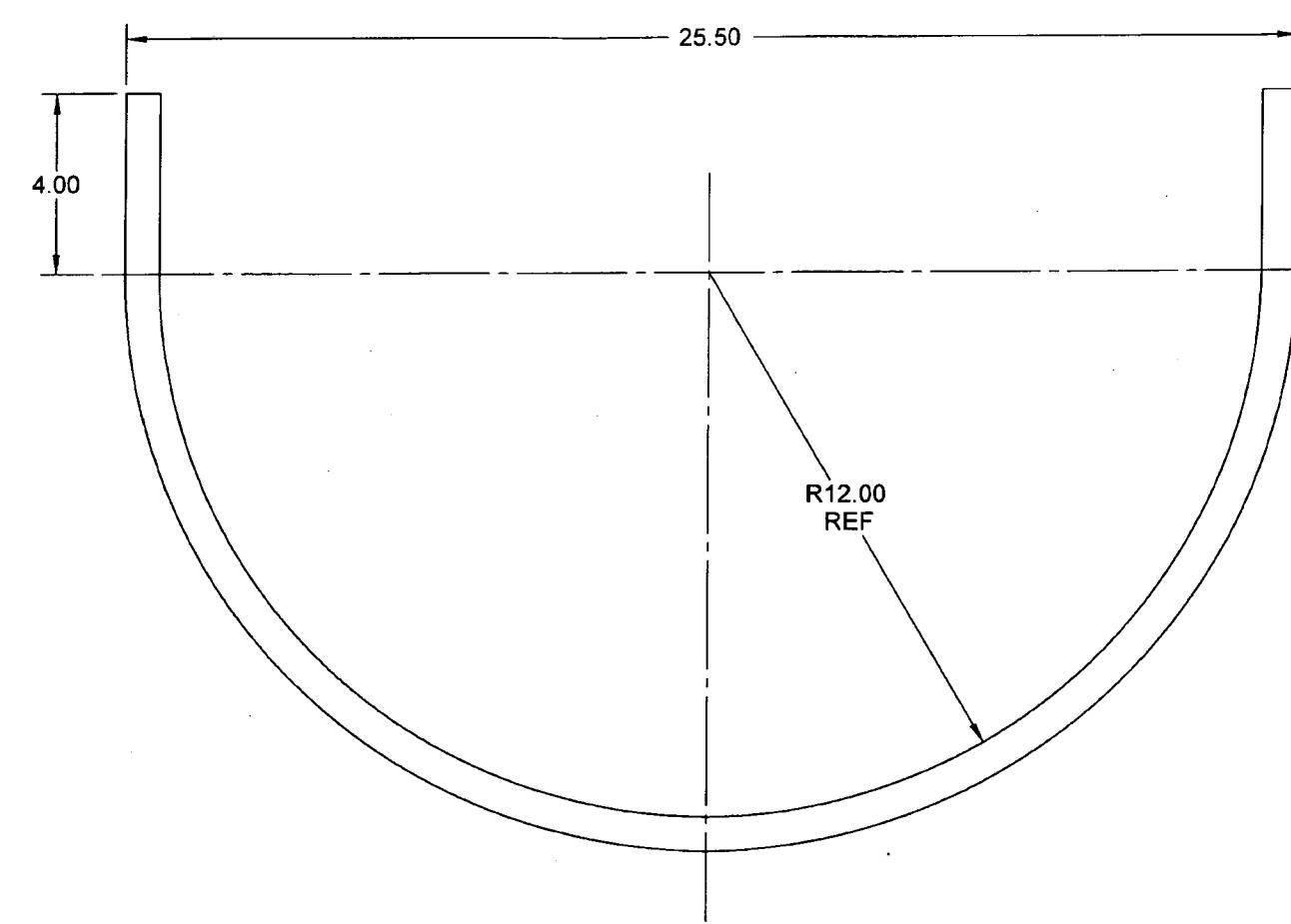
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08.03.17 *MJ*

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CHECKED	<i>PF</i>	DRAWING NO.
MFG. APPR.	<i>PF</i>	D3746
APPROVED	<i>PF</i>	REV. B
DE APPR.	<i>PF</i>	SHEET 2 OF 3
DATE	08.03.03	SCALE
		NTS

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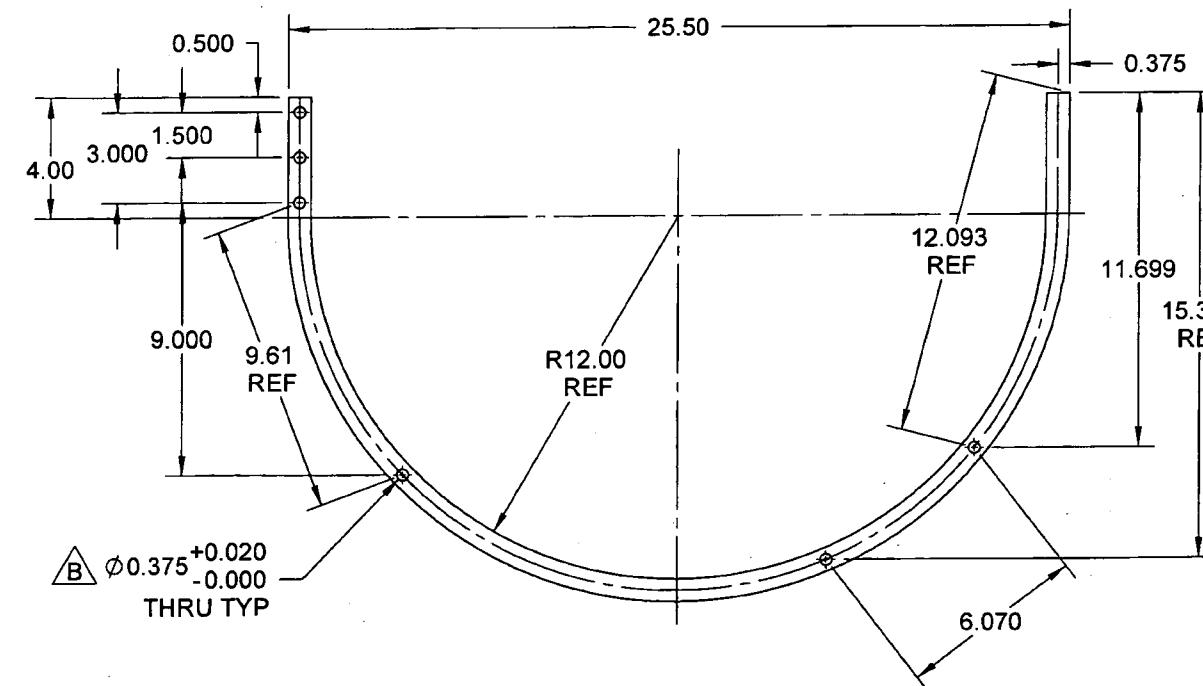
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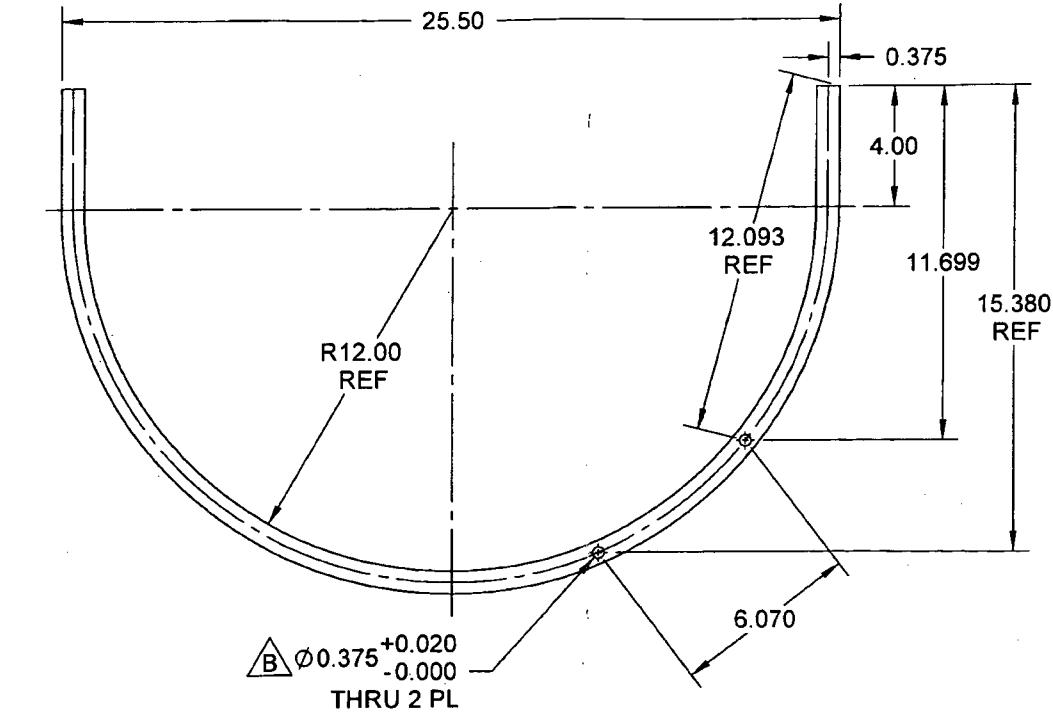
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D3746-5 RIB



D3746-7 RIB

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08/07/07 JAD

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CHECKED	LG	DRAWING NO.
MFG. APPR.	AK	REV. B
APPROVED		D3746
DE APPR.	#	SHEET 3 OF 3
DATE	08.03.03	SCALE
		NTS
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